



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D2530

Job Sheet 195045



Part No: D2530

Job Qty: 8 pcs

9 DAS  
21  
9-89

Part Name: Handle Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off          |
|-------|-------------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                   |
| 100   | Large Fab - Welded Assy-1     | 8 pcs | 6/20/19    |          | 0.12      | 1.55    | Large Fab - 1         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 10        |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 2         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 3         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 4         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 5         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 6         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 7         |           | 11                |
|       |                               |       |            |          |           |         | Large Fab - 8         |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 9         |           |                   |
| 110   | QC 5                          | 8 pcs | 6/20/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 12             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 17             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 18             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 19             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 22             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 24             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 3              |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 43             |           | DAS<br>43<br>9-89 |
|       |                               |       |            |          |           |         | QC 5 - 49             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 51             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 58             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 68             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 9              |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 50             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 30             |           |                   |
|       |                               |       |            |          |           |         | QC 5 - 40             |           |                   |
| 120   | Large Fab - Welded Assy-2-B4B | 8 pcs | 6/20/19    |          | 0.00      | 3.20    | Large Fab - 1 - B4B   |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 10 - B4B  |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 2 - B4B   |           |                   |
|       |                               |       |            |          |           |         | Large Fab - 3 - B4B   |           |                   |



Container No: S186637



Part: D2530

Job No: 195045

Serial No/Batch: S186637

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/03/19

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|                                     |          |         |           |  |                       |              |
|-------------------------------------|----------|---------|-----------|--|-----------------------|--------------|
|                                     |          |         |           |  | Large Fab - 4 - B4B   |              |
|                                     |          |         |           |  | Large Fab - 5 - B4B   |              |
|                                     |          |         |           |  | Large Fab - 6 - B4B   |              |
|                                     |          |         |           |  | Large Fab - 7 - B4B   | 12           |
|                                     |          |         |           |  | Large Fab - 8 - B4B   |              |
|                                     |          |         |           |  | Large Fab - 9 - B4B   |              |
|                                     |          |         |           |  |                       |              |
| 130 QC 9                            | 8<br>pcs | 6/20/19 | 0.00 0.00 |  | QC 9 - 10             |              |
|                                     |          |         |           |  | QC 9 - 18             |              |
|                                     |          |         |           |  | QC 9 - 24             | DAS          |
|                                     |          |         |           |  | QC 9 - 43             | 24           |
|                                     |          |         |           |  | QC 9 - 50             | 9-89         |
|                                     |          |         |           |  | QC 9 - 9              |              |
|                                     |          |         |           |  |                       | JUN 0 4 2019 |
| 140 QC 5                            | 8<br>pcs | 6/20/19 | 0.00 0.00 |  | QC 5 - 10             |              |
|                                     |          |         |           |  | QC 5 - 12             |              |
|                                     |          |         |           |  | QC 5 - 17             |              |
|                                     |          |         |           |  | QC 5 - 18             |              |
|                                     |          |         |           |  | QC 5 - 19             |              |
|                                     |          |         |           |  | QC 5 - 22             |              |
|                                     |          |         |           |  | QC 5 - 24             | DAS          |
|                                     |          |         |           |  | QC 5 - 3              | 24           |
|                                     |          |         |           |  | QC 5 - 43             | 9-89         |
|                                     |          |         |           |  | QC 5 - 49             |              |
|                                     |          |         |           |  | QC 5 - 51             |              |
|                                     |          |         |           |  | QC 5 - 58             |              |
|                                     |          |         |           |  | QC 5 - 68             |              |
|                                     |          |         |           |  | QC 5 - 9              |              |
|                                     |          |         |           |  | QC 5 - 50             |              |
|                                     |          |         |           |  | QC 5 - 30             |              |
|                                     |          |         |           |  | QC 5 - 40             |              |
| 150 Powdercoat - 4 Black Sand - B4B | 8<br>pcs | 6/20/19 | 0.00 0.30 |  | Powdercoat - 1 - B4B  |              |
|                                     |          |         |           |  | Powdercoat - 2 - B4B  |              |
|                                     |          |         |           |  | Powdercoat - 3 - B4B  |              |
|                                     |          |         |           |  | Powdercoat - 4 - B4B  |              |
|                                     |          |         |           |  |                       | BL 19-6-4    |
| 160 QC 3                            | 8<br>pcs | 6/20/19 | 0.00 0.00 |  | QC 3 - 10             |              |
|                                     |          |         |           |  | QC 3 - 13             |              |
|                                     |          |         |           |  | QC 3 - 15             |              |
|                                     |          |         |           |  | QC 3 - 17             |              |
|                                     |          |         |           |  | QC 3 - 18             |              |
|                                     |          |         |           |  | QC 3 - 2              |              |
|                                     |          |         |           |  | QC 3 - 28             |              |
|                                     |          |         |           |  | QC 3 - 3              |              |
|                                     |          |         |           |  | QC 3 - 30             |              |
|                                     |          |         |           |  | QC 3 - 34             |              |
|                                     |          |         |           |  | QC 3 - 36             |              |
|                                     |          |         |           |  | QC 3 - 41             |              |
|                                     |          |         |           |  | QC 3 - 51             |              |
|                                     |          |         |           |  | QC 3 - 58             |              |
|                                     |          |         |           |  | QC 3 - 59             |              |
|                                     |          |         |           |  | QC 3 - 68             |              |
|                                     |          |         |           |  | QC 3 - 9              |              |
|                                     |          |         |           |  | QC 3 - 40             | DAS          |
|                                     |          |         |           |  | QC 3 - 19             | 40           |
|                                     |          |         |           |  | QC 3 - 43             | 9-89         |
|                                     |          |         |           |  | QC 3 - 24             |              |
| 170 Packaging 3-1 - Stock - B4B     | 8<br>pcs | 6/20/19 | 0.00 0.00 |  | Packaging 3 - 1 - B4B |              |
|                                     |          |         |           |  | Packaging 3 - 2 - B4B |              |
|                                     |          |         |           |  | Packaging 3 - 3 - B4B |              |
|                                     |          |         |           |  | Packaging 3 - 4 - B4B |              |
|                                     |          |         |           |  | Packaging 3 - 5 - B4B |              |

|                                                                                                                                                                                                                                                                            |            |     |         |                        |                 |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|-----|---------|------------------------|-----------------|
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 6 - B4B  |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 7 - B4B  |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 8 - B4B  |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 9 - B4B  |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 10 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 11 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 12 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 13 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 14 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 15 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 16 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 17 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 18 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 19 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 20 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 21 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 22 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 23 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 24 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 25 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 26 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 27 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 28 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 29 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 30 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 31 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 32 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 33 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 34 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 35 - B4B |                 |
|                                                                                                                                                                                                                                                                            |            |     |         | Packaging 3 - 36 - B4B |                 |
| 180                                                                                                                                                                                                                                                                        | QC 21 - SA | 8   | 6/20/19 | 0.00 0.00              | QC 21 - SA - 21 |
|                                                                                                                                                                                                                                                                            |            | pcs |         |                        | QC 21 - SA - 70 |
|                                                                                                                                                                                                                                                                            |            |     |         |                        | QC 21 - SA - 53 |
| Part Op 100 - (Fabricate per Drwg) 1-Cut to length as per Drwg D2530<br>Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)<br>120 - 1-Weld as per Drwg D2530 and QSI 004 using Welding Jig DT8301<br>130 - (QC9- Inspect visual per QSI004- Fusion Welds) |            |     |         |                        |                 |

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9-85

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140 - (QC5- Inspect part completeness to step on W/O)

150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME:

2:00

007:300° 1138940.

FINISH TIME:

2:30

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

180 - (QC21- Final Inspection - Work Order Release)

**Job BOM**

| Part / Item      | Component Name              | Quantity              | Operation                          | Container |
|------------------|-----------------------------|-----------------------|------------------------------------|-----------|
| M304TR0.750W.049 | 304 Round Tube .750 X .049W | 22.9200 ft (2.865 ea) | 100-Large Fab - Welded Assy-1      | 5163766   |
| D2534            | Lock Plate                  | 16 pcs (2 ea)         | 120-Large Fab - Welded Assy-2- B4B | 5155155   |

**Job Allocations**

| Operation                          | Component Part   | Required | Inventory | Allocated |
|------------------------------------|------------------|----------|-----------|-----------|
| 100-Large Fab - Welded Assy-1      | M304TR0.750W.049 | 23       | 189       | 0         |
| 120-Large Fab - Welded Assy-2- B4B | D2534            | 16       | 21        | 0         |

**Part Specifications**

Specifications could not be found.

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010131

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |